

Work Order ID 86873 -1

\*86873\*

Page 1

July-06-12 3:19:42 PM

Item ID: D3017-7

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 7/06/12

Start Qty: 6.00

\*6\*  
\*6\*

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-10

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3017	Rev B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3017

4130 1050

Dwg Rev: B

Prog Rev: B

2-Deburr

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 0 JM 12-9-21

20 0 JM 12-9-21



# Work Order ID 86873

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Page 2

Item ID: D3017-7

Revision ID:

Item Name: Lug

Start Date: 7/06/12

Start Qty: 6.00

**\*6\***

Required Date: 8/10/12

Req'd Qty: 6.00

**\*6\***

Reference:

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

*Smb*  
*129.21*

**\*120\***

QC

Quality Control

Memo

0.00

*20*

130

**\*130\***

Brake NC

Brake NC

NC BRAKE

0.00

Memo

1-Deburr

0.00

2-Form as per Dwg D3017 using DT8598

*①*

*12-10-30*

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*DAS*  
*15*  
*2-3*

*1210-31*

*1*



THE NEW YORK  
LIBRARY

ASTOR LENOX  
TILDEN FOUNDATION

# Work Order ID 86873

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Page 3

Item ID: D3017-7

Revision ID:

Item Name: Lug

Start Date: 7/06/12

Start Qty: 6.00

Required Date: 8/10/12

Req'd Qty: 6.00

Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

**\*150\***

Packaging

Packaging

0.00

Memo

0.00

Identify and bag with light oil (Vactra oil #2), then Stock  
Location: W/P

12/10/31

160

**\*160\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

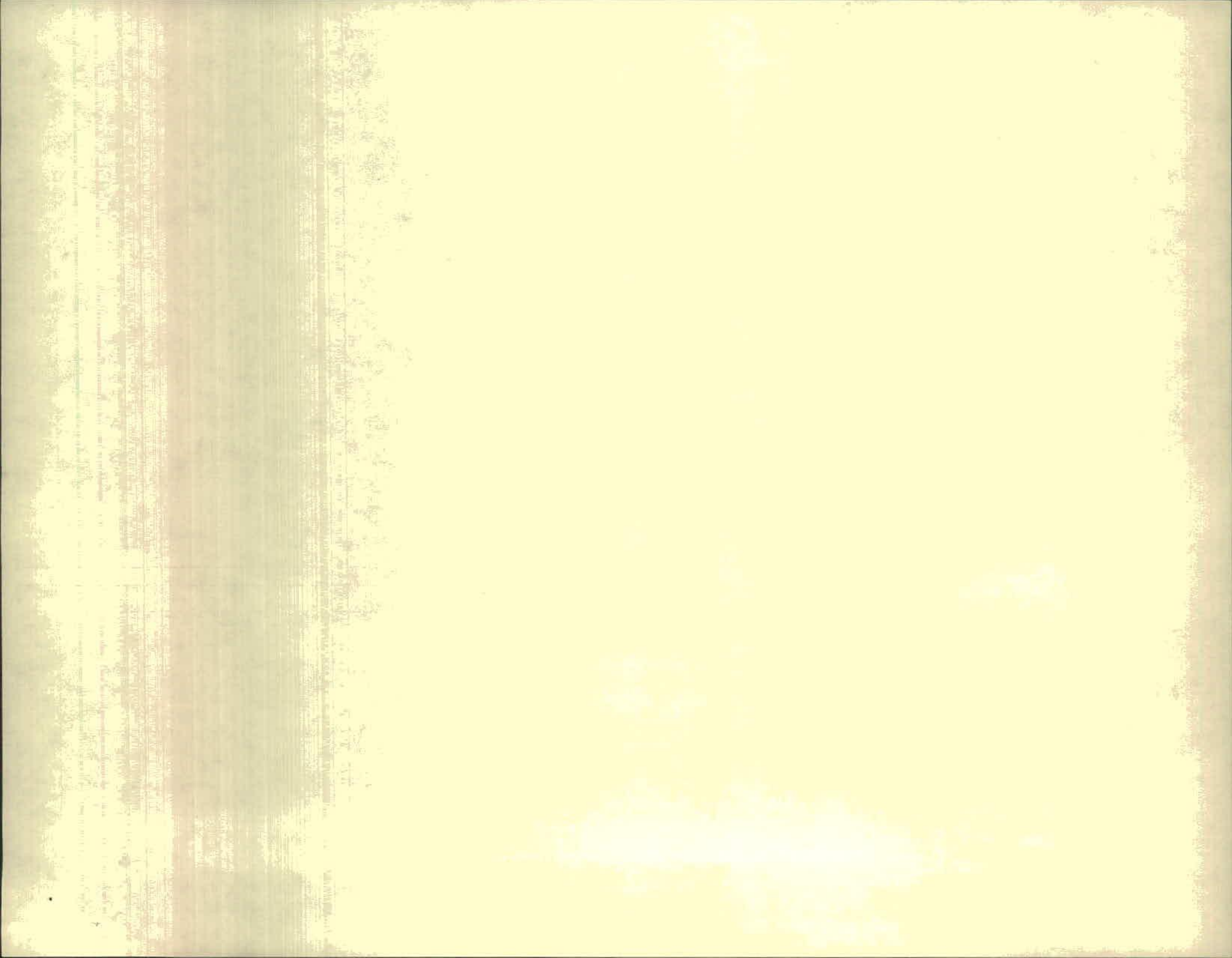
0.00

Memo

0.00

12/10/31

12/10/31





# Picklist Print

July-06-12 3:19:42 PM

Page 1

Work Order ID: 86873  
Parent Item: D3017-7  
Parent Item Name: Lug

Start Date: 7/06/12  
Start Qty: 6.00

Required Date: 8/10/12  
Required Qty: 6.00

Comments: IPP: B03.05.09ReformatKJ/RF  
IPP Rev: C 08-04-11 now made on water jet DD verified by: EC  
revB DD verified by: JLM IPP RevB: as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	3.8000	0.102	0.6442105			

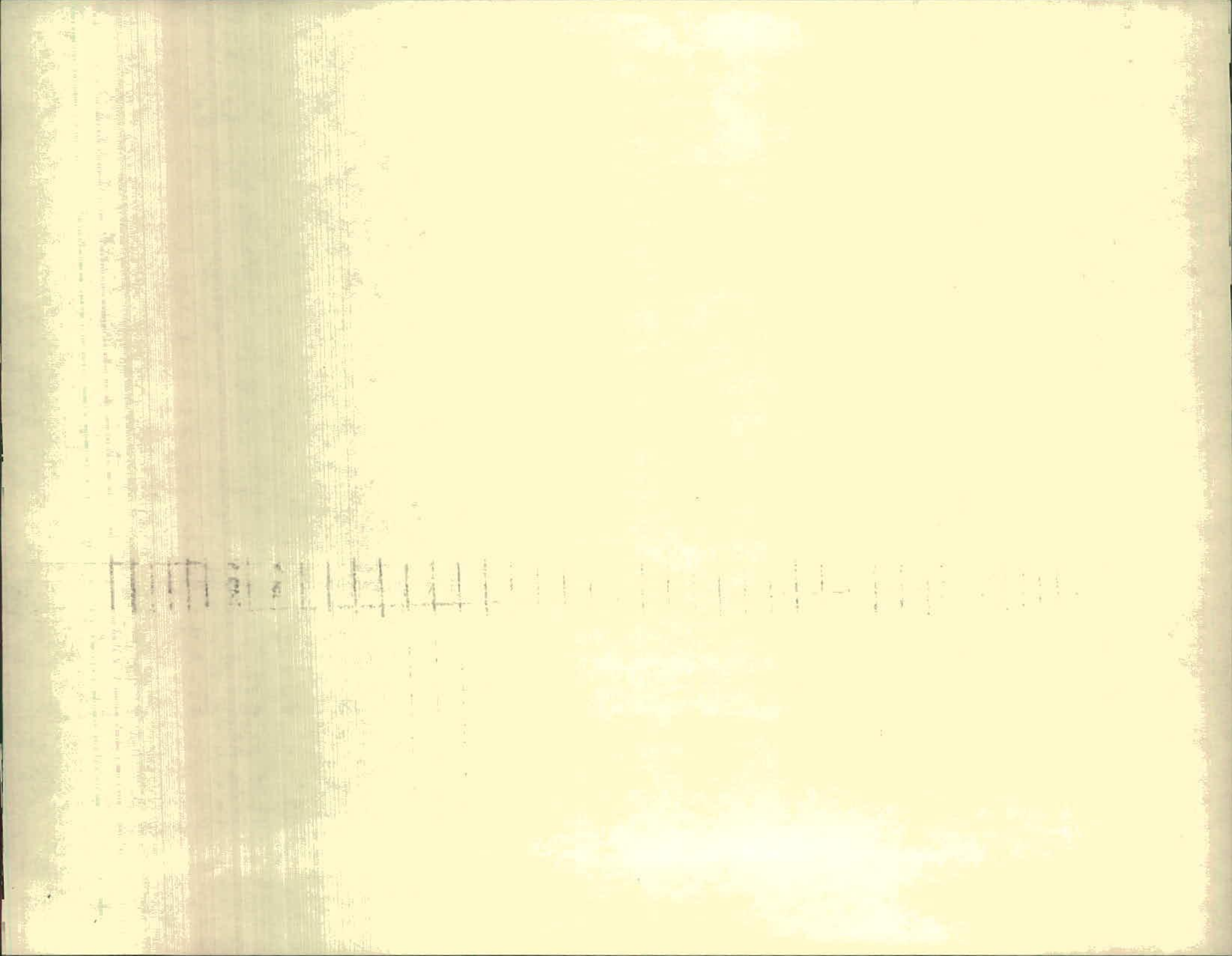
2.35 0.7

123049

Location	Loc Qty	Loc Code
MAT020	3.8	
11612	3.8	

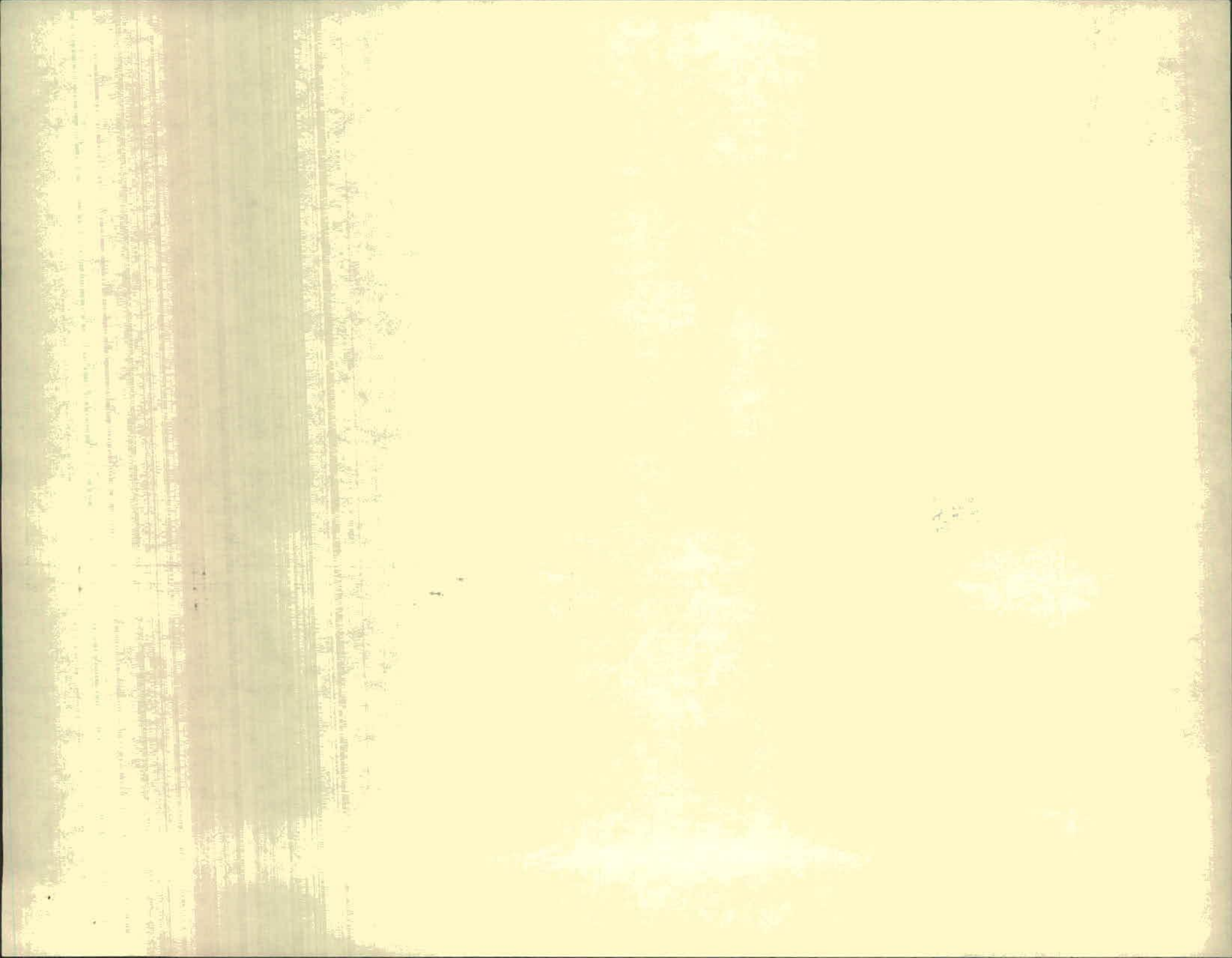
123049

123049

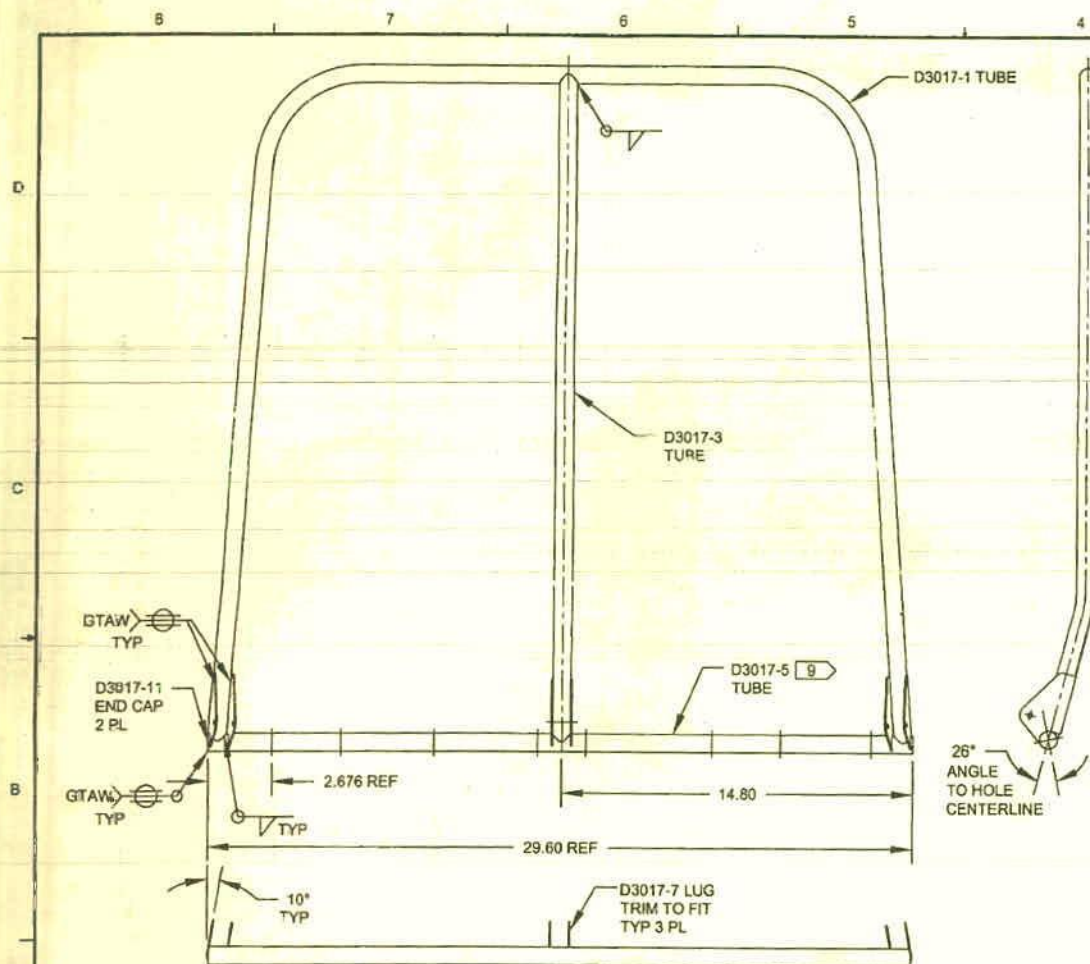












**D3017-041 BACK FRAME ASSEMBLY**

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 8273  
1120710

**RELEASED**  
R 2010-02-02  
WP

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 4.50 lbs
  - 8) WELD PER DART QSI 004
  - 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG. -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C8-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

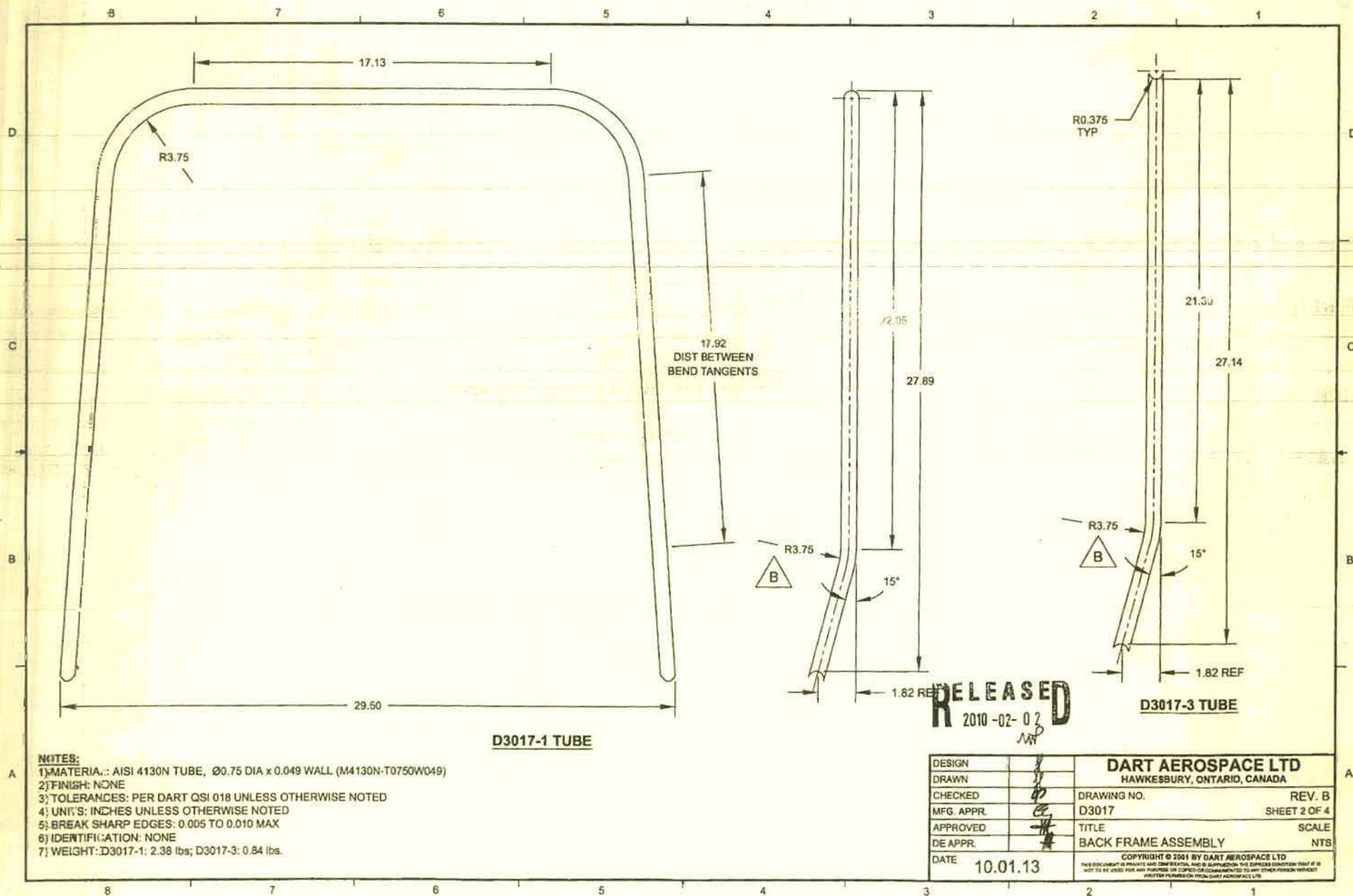
DRAWING NO. REV. B  
D3017 SHEET 1 OF 4  
TITLE SCALE  
BACK FRAME ASSEMBLY NTS

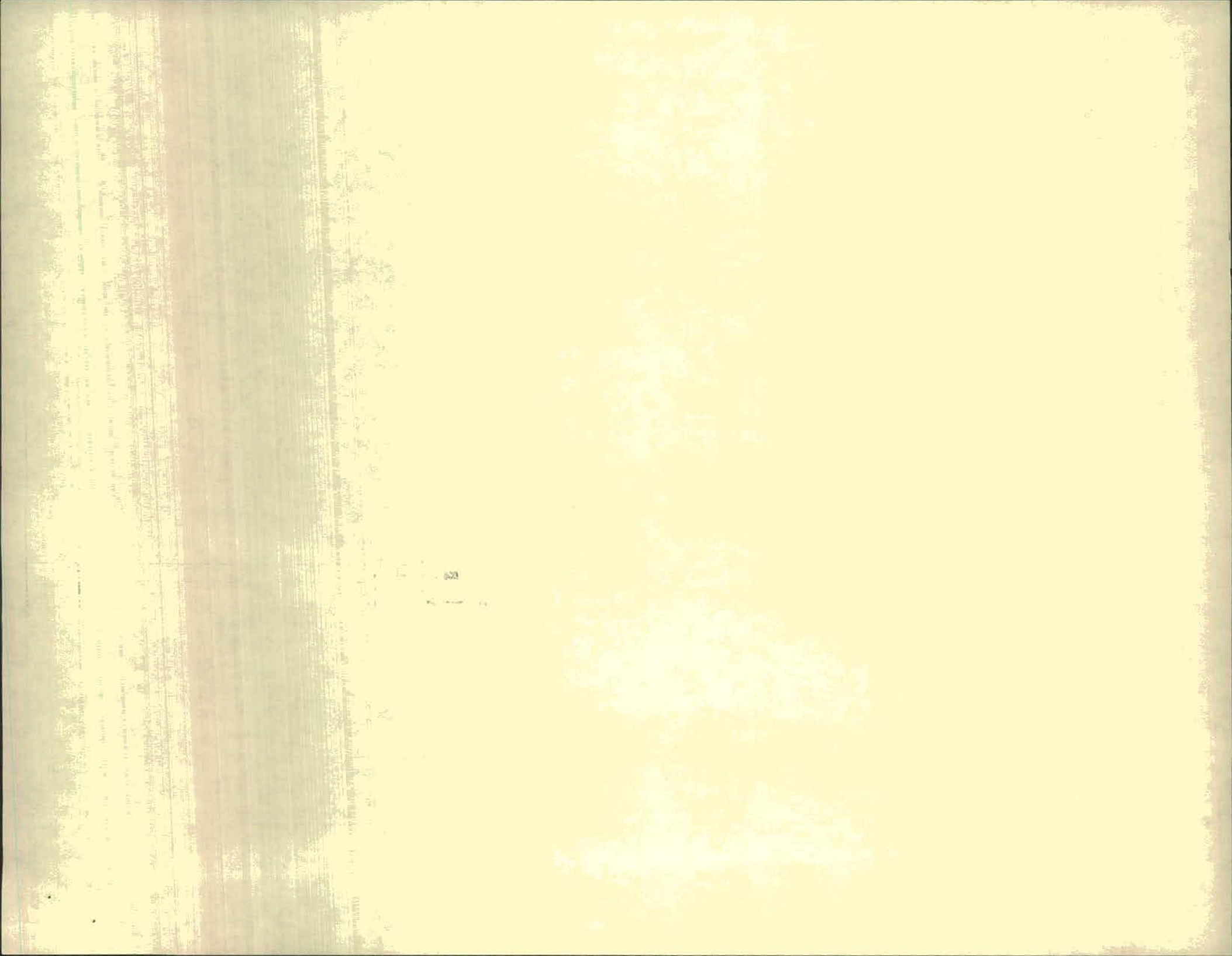
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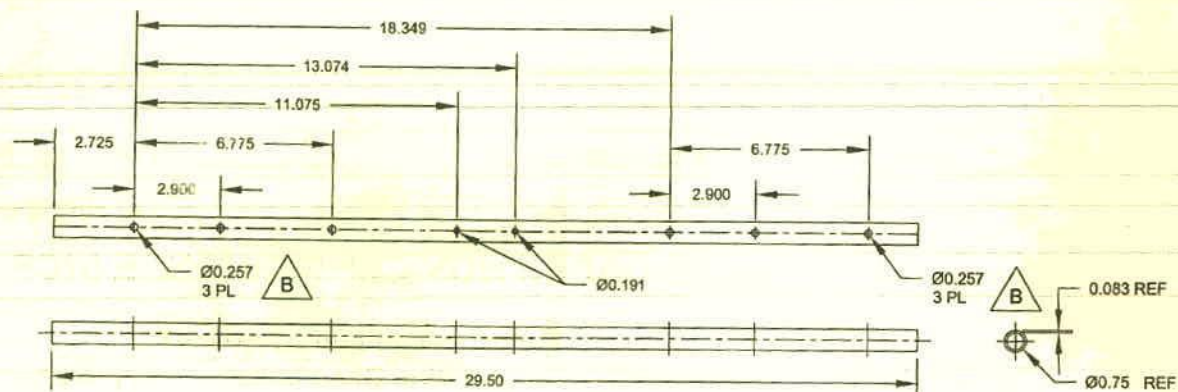


86873









D3017-5 TUBE

RELEASED  
2010-02-02  
MP

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE,  $\varnothing 0.75$  DIA x 0.083 WALL (M4130N-T0750W083)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.89 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. B
MFG APPR.	2	D3017	SHEET 3 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	BACK FRAME ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

.049 REF

1.86

R0.375

**D3017-7 LUG**  
BENDING DETAIL  
MAKE FROM D3017-7F

.049 REF



Ø0.750

**D3017-11 END CAP**

R0.25  
TYP

0.872

0.000

Ø0.191  
TYP 2 PL

3.244  
REF

2.063

2.500

R0.44

3.100  
3.183 REF

2.060

1.622

0.876

0.776 REF

0.562

0.000

R0.375  
TYP

R0.015

**D3017-7F FLAT PATTERN**  
PART IS SYMMETRIC  
ABOUT CENTERLINE

96873

**RELEASED**  
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1



